

Date: Tuesday, 7/4/2006 3:18:26 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUBBLE WINDOW, LH
Job Number : 27745
Estimate Number : 11393
P.O. Number :
This Issue : 7/4/2006 S.O. No. :
Prsht Rev. : NC Part Number : D32691
First Issue : 1/1 Type : PURCHASED PARTS Drawing Number : D3269 REVC/DSI9329 B
Previous Run : 27745 Project Number : N/A
Material : C/B
Written By : Due Date : 7/5/2006 Qty: 10 Um: Each
Checked & Approved By :
Comment : Est. A 05.03.22 New issue KJ/JLM
Est Rev:B Per Rev C 06-07-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1602

C207105106

Manufacture D3269-1 as per Dwg D3269

Possible Supplier: Canus

Material release note is required

2.0 D32691P Bubble Window, LH R44



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Bubble Window, LH R44

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Engrave P/N & B/N on lower edge as per Dwg D3269

2-Wrap window in plastic wrap in a clean area.

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE WINDOW, LH

Job Number: 27745

Part Number: D32691

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



7-6-08.23

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

M/R

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-14	4.0	Window has voids in material causing a blur in the vision path needed by the pilots.		Return to supplier (Canus) and have them inspect for root cause of the voids and replace the window, as per NCR 067				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

CANUS PLASTICS INC.

10 Lisgar Street

Ottawa, ON

K2P 0E2

Phone: 613 232 2657

Fax: 613 232 6214

info@canusplastics.com

www.canusplastics.com

Packing Slip 127740

CUSTOMER NO. 163233

BILL TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

SHIP TO: SAME

Attn: Accounts Payable

(613)632-3336

DATE	SHIP VIA	F.O.B.	TERMS
07/27/06	CANUS	Our Dock	Net 30 days

P.O. NUMBER	ORDER DATE	SALESPERSON
PO00001602	07/27/06	TM

PART NUMBER	DESCRIPTION	REQ.	QUANTITY SHIPPED	B.O.
MFG	D3269-1 LEFT BUBBLE WINDOW	7	7	
MFG	D3269-2 RIGHT BUBBLE WINDOW	7	7	

Non-Conformance Report

NCR 067

Raised by: DALE TREPMER

Source: Q.C.

Sheet No. 1 of 1

Non-Conforming Dept./Supplier: CANUS

Date: 06.07.24

Product/Service: D3269-2 RH bubble windows

Priority: HIGH LOW

Area of Standard:

Section A

QSI

Description of Non-Conformance

QSP

QSPM

REFERENCE ONLY

Root Cause: Material Received from Supplier

Documents:

P/O 1602

Invoice

W/O

Batch No. 27746/45

TSR

Drawing D3269 Page

is too thin. Windows were made with .125" thick mat'l, Dwg states .188" thick material. All Minimum material thickness dimensions, are all way under tolerance. Also 1x D3269-1 (B27745) window has voids in the view area for the Pilot, causing a blur.

Forward to Director, Quality Assurance on completion of this box

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.

Section B

Corrective Action

Responsible for Investigation/CA: L.L. To be done by: 06/08/05

No	Initial	Action Description	Responsible	Due date	Sign/Date
1.	D.T.	Notify Supplier and return have them replace replace windows to correct material thickness, and ensure they have the proper revision of the Dwg.	J.M.	06/07/09	see NCR 067
2.	D.T.	Get corrective from Supplier to ensure this does not happen again	D.L.	06/08/01	06/08/08
3.	J.M.	EMPLOYEE ERROR — EMPLOYEE REPRIMANDED. Swap & destroy 1st set of 3 windows. will be replaced No charge with	J.M.	06-08-01	2608-06
4.	J.M.	Return -1 window to supplier to investigate the cause of the voids in the window			

See JASON or DALE for original copy

Preventive Action Required: NO YES #

Fault Category: Supplier

Section C

Verification of C/A

Responsible for Verification of CA: DALE TREPMER

No	Verification Method	Sign	Date
1.	Supplier notified of Mat'l thickness requirement and of revisions of dwg's.	(Signature)	06/08/04
2.	Corrective action was employee reprimanded		
3.	Windows were destroyed and replaced.		

Forward to DQA on Completion of Verification

DQA: _____

Date: _____

QA Purposes only

N/C Closed

Date

DART AEROSPACE
1270 Aberdeen
Hawkesbury, ON

N° DE COMMANDE - ORDER NO. P.O 1602		DÉP. - DEPT.		DATE 06-08-25	
VENDU À - SOLD TO			EXPÉDIÉ À - SHIP TO Tonus Plastics 300 LISCAR		
ADRESSE - ADDRESS			ADRESSE - ADDRESS 011202, ON K2P0E2		

DATE D'EXPÉDITION - SHIPPING DATE		VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
1		D3269-1	B27745		
<p>Window has words in material causing blurred vision</p> <p>Please advise if replacement or credit will be issued</p>					
<p>was this closed? yes.</p>					
				TPS/GST	
				TVP/PST	
274708				SIGNATURE	
				N° LIC - LIC NO.	
				TOTAL	